

MARKED-UP COPY OF SUBSTITUTE SPECIFICATION
ELECTROMAGNET CORE AND METHOD OF MANUFACTURING THE SAME

Cross Reference to Prior Related Applications

This application is a U.S. national phase application under 35 U.S.C. § 371 of International Patent Application No. PCT/JP2004/015985, filed October 28, 2004, and claims the benefit of Japanese Patent Application No. 2003-375194, filed November 5, 2003, both of which are incorporated by reference herein. The International Application was published in Japanese on May 19, 2005 as International Publication No. WO 2005/045857 A1 under PCT Article 21(2).

Technical Field

———[0001]

The present invention relates to an electromagnet core used for a liquid fuel injector and a method of manufacturing the electromagnet core.

Background Art

———[0002]

Conventionally, an electromagnet core made of a powder

composite material has been proposed. For example, there has been proposed a measuring valve control electromagnet used for a liquid fuel injector. The electromagnet includes a fixing core made of a magnetic material, an excitation core, and a valve activating armature. The fixing core is formed by pressing a mixture of a powder iron material and an epoxy binder. After the core is formed, the core is ~~subjected~~subject to a ~~calcination~~calcinations process. The powder iron material is made of ferrite. The epoxy binder is selected from various types of epoxy resins. GenerallyThe epoxy resin of from 2 wt% to 50 wt% is contained in the mixture.

———[0003]

In addition, an iron powder grain is covered with a thin phosphate layer (insulating film) having an electrical insulating property. In addition, as an example, there has been proposed an iron powder grain containing a polymer additive (for example, polyimide or phenol resin) of 0.5 wt%.

———[0004]

The epoxy binder or the polymer additive has an electrical insulating function and binds the grains. Due to high electric resistance between the powder grains, eddy current is not generated at the associated locations.~~location~~. (See

———[Patent Document 1]——Japanese Unexamined Patent Application

Publication No. H7-310621

~~————[Patent Document 2]~~ and PCT Japanese Translation Patent
Publication No. 2000-501570.)

Disclosure of the Invention

Problems to be Solved by the Invention

~~————[0005]~~

Since a A liquid fuel injector with an electromagnet is usually disposed on the pathwayway of a liquid fuel supply path. Therefore, an electromagnet core which is integrally installed in the liquid fuel injector may comebe in a direct contact with a liquid fuel or in contact with a vaporized gas of the liquid fuel. For this~~the~~ reason, a chemical resistance is required for the electromagnet core. On the other hand, the liquid fuel injector with the electromagnet core is integrally attached to an engine. Therefore, the electromagnet is exposed to a high temperaturest~~temperature~~, so that a heat resistance is required for the electromagnet core as well.

~~————[0006]~~

The electromagnet core is formed by performing a pressing process on a mixture of a raw powder made of a soft magnetic

material and a binder. As the a volume ratio of the raw powder is made higher, a-performance of the electromagnet such as magnetic permeability of magnetic flux density is improved.~~more-~~
excellent.

———[0007]

However, in the aforementioned conventional technique, since the binder for the raw powder is an epoxy resin, a polyimide resin, or a phenol resin having a heat resistance of from 50 to 160 °C, there is a problem in that the chemical resistance or the heat resistance of the electromagnet core is low. Therefore, the conventionally proposed electromagnet core has a limitation for~~to~~ use as~~for~~ the measuring valve control electromagnet used in~~for~~ a liquid fuel injector.

In a method of manufacturing an electromagnet core, a flow initiating material is mixed into the mixture of raw powder and binder in order to increase the~~a~~ flowing property thereof in a pressing process. However, the flow initiating material has a limitation in ~~to~~ increasing the flowing property. As a result, the volume ratio of the raw powder in the electromagnet core must be further increased.

———[0008]

In order to solve the aforementioned problems, an object of the present invention is to improve a-chemical resistance and a-

heat resistance of an electromagnet core used for a liquid fuel injector. In addition, another object of the present invention is to increase the a volume ratio of a raw powder portion by improving the a-flowing property of a mixture of a raw powder and a binder in a ~~method of manufacturing~~ an electromagnet core used for a liquid fuel injector which is formed by performing a pressing process on the mixture of the raw powder made of a soft magnetic material and the binder.

~~Means for Solving the Problems~~

~~———[0009]~~

According to anonea ~~first~~ aspect of the present invention, there is provided an electromagnet core made of a soft magnetic material and capable of accommodating ~~including~~ a coil, wherein the electromagnet core is formed with a soft magnetic powder and a binder for the soft magnetic powder, and the binder is made of a polyimide resin.

~~———[0010]~~

According to anothera ~~second~~ aspect of the present invention, in the electromagnet core according to the ~~first~~ aspect above, thea ~~volume~~ ratio of the polyimide resin to the soft magnetic powder is in a range of from 0.05 wt% to 1.0 wt%.

~~———[0011]~~

According to another~~a third~~ aspect of the present invention, in the electromagnet core according to the above aspect ~~the first or second aspect~~, the electromagnet core is used for a measuring valve control electromagnet used for a liquid fuel injector.

———[0012]

According to another~~a fourth~~ aspect of the present invention, there is provided a method of manufacturing an electromagnet core made of a soft magnetic material and capable of accommodating~~including~~ a coil, by the method comprising steps of~~inserting~~ a mixture of soft magnetic powder and a binder made of a polyimide resin into a molding dieframe~~and~~ molding the mixture by using a pressing process, wherein a lubricant layer is formed on a surface of a receiving portion of the molding dieframe for receiving the mixture.

———[0013]

According to another~~a fifth~~ aspect of the present invention, in the electromagnet core according to the ~~fourth aspect~~ just described, the receiving portion is heated from a room temperature to a high temperature, and before the mixture is inserted, the surface of the receiving portion is coated with a lubricant solution, and a moisture in the coated lubricant solution is vaporized by the~~using~~ a heat of the receiving

portion, thereby forming the lubricant layer.

———[0014]———

According to another~~a sixth~~ aspect of the present invention, in the electromagnet core according to the ~~fifth aspect~~ just described, a flow initiating material is added to the mixture.

Effects~~Effect~~ of the Invention

———[0015]———

According to one~~the first~~ aspect of the present invention, the polyimide resin having a thermally and chemically stabilized molecular structure is used for the binder for the soft magnetic powder, so that it is possible to improve the heat resistance and the chemical resistance in comparison with a conventional core.

———[0016]———

According to another~~the second~~ aspect of the present invention, the ~~volume~~ ratio of the polyimide to the soft magnetic powder is in a range of from 0.05 wt% to 1.0 wt%, so that the molding can be effectively performed, and a desirable~~the~~ volume ratio of the soft magnetic powder in the core can be secured.

———[0017]

According to another~~the third~~ aspect of the present invention, since the electromagnet core having an improved heat resistance and~~er~~ chemical resistance is used as a valve control electromagnet of the liquid fuel injector, the injector attached to an engine can be effectively operated.

———[0018]

According to another~~the fourth~~ aspect of the present invention, since the lubricant layer formed on surfaces of the receiving portion of the molding die imparts or improves the lubricating property between the soft magnetic powder and the surfaces, a ~~friction~~ between the soft magnetic powder and the surfaces caused by the press pressure at the molding process can be reduced. As a result, gaps between the grains of the soft magnetic powder and between the soft magnetic powder and the binder can be reduced at the molding process.

———[0019]

According to another~~the fifth~~ aspect of the present invention, the lubricant layer above is formed by vaporizing the moisture of the lubricant solution by using the heat of the receiving portion, so that the thickness of the lubricant layer can be reduced. As a result, the molding can be performed with improved accuracy~~accurately~~.

————[0020]

According to another~~the sixth~~ aspect of the present invention, the flow initiating material is added, so that the flowing property of the mixture at the pressing process or the like can be further improved. As a result, the~~a~~ density of the core can be further increased.

Best Mode for Carrying out the Invention

————[0021]

Now, preferred embodiments of the present invention will be described. The scope and spirit~~spirit~~ of the present invention disclosed in the claims is not limited to the embodiments described herein~~later~~. Furthermore, any of ~~All~~ the components described herein~~layer~~ is not intended to be an essential component~~components~~ of the present invention.

————~~First Embodiment~~

————[0022]

Figs. 1 to 5 show a~~an~~ ~~first~~ embodiment of the present invention. An electromagnet 1 includes a core 2 and an excitation ~~core~~ coil 3 (see Fig. 1). The core 2 has a shape of a cylinder in which ~~where~~ a through hole 4 is formed along an axis z. A circular groove 5 is formed ~~in~~ on one side of the core

2 with thea center thereof aligned with the axis z. TheA cylindrical coil 3 is inserted into the groove 5 in a concentric manner. A plungerflanger 6 which is a moving member is disposed along the axis z. An armature 6a made of magnetite, or the like and having a shape substantially of a substantial disk is disposed on a distal end of the plungerflanger 6, so that the armature can detachably contact one side surface of the coil 3 and one side surface of the core 2. When a current is applied to the coil 3, the electromagnet is excited, so that the plungerflanger 6 is moved in the direction of the axis z. Referring to Fig. 5, when the current is applied to the coil 3, the armature 6a is suctioned into the electromagnet 1.

———[0023]

The electromagnet 1 is disposed in an injector of a liquid fuel spray apparatus for an engine. As shown in Fig. 5, the injector 7 includes a valve body 9 which has a liquid fuel spray hole 8 at a distal end thereof, a valve seat 10 which is formed in an inner end portion of the liquid fuel spray hole 8, and a needle-shaped valve 11 which is disposed in the valve body 9. In addition, the injector 7 includes an electromagnet 1 which drives the plungerflanger 6 connected to the needle-shaped valve 11 for opening/closing the liquid fuel spray hole 8 and a return spring (not shown) for pressing the armature 6a and the plungerflanger 6 so as to sustain the needle-shaped valve 11 in

a closed state thereof. In addition, a liquid fuel supply hole 13 is disposed at the other side of the valve body 9. The liquid fuel supply hole 13 is connected to a liquid fuel pump (not shown). A liquid fuel F is supplied from the liquid fuel pump with a predetermined pressure thereof. In the injector 7, when the coil 3 is applied with a driving voltage and an excitation current, the armature 6a and the ~~plunger~~~~flanger~~ 6 are suctioned ~~onto~~~~into~~ the excitation coil 3, so that the needle-shaped valve 11 allows the liquid fuel spray hole 8 to open. The needle-shaped valve 11 is maintained in the opened state until ~~the~~ magnetic field of the electromagnet 1 is removed. When the liquid fuel spray hole 8 opens, the liquid fuel is sprayed.

———[0024]

_____The core 2 is formed by integrally fixing a soft magnetic powder 14 with a binder 15 (see Fig. 2). The soft magnetic powder 14 is made of an electromagnetic soft iron or a silicon steel which is are relatively easy to magnetize or demagnetize. An A insulating film 16 which magnetic force lines may penetrate is formed on a surface of the soft magnetic powder 14. The binder 15 is made of a polyimide resin, that is, a polymer having a molecular structure ~~wherein~~~~where~~ thermally, and ~~chemically~~~~chemical~~ stabilized imide rings (~~heterocyclic~~~~complex~~ rings) or aromatic rings are disposed ~~within~~~~in~~ a main chain thereof. A grain size (maximum diameter~~width~~) of the soft

magnetic powder 14 is in a range of from 10 μm to 200 μm , and more preferably, from 10 μm to 100 μm . This is because, if the grain size (maximum diameterwidth) of the soft magnetic powder 14 is less than 10 μm , the manufacturing thereof is difficult, and if the grain size (maximum diameterwidth) is more than 200 μm , sufficient resistivity cannot be obtained, and furthermore, ~~so that~~ sufficient strength cannot be obtained.

———[0025]———

The polyimide resin is made of a wholly aromatic polyimide, a bismaleidebismalade polyimide, or an additive-type polyimide. The additive amount added thereof in relation to the soft magnetic powder 14 is in a range of from 0.05 wt%W% to 1.0 wt%W%, and more preferably, from 0.1 wt% to 0.5 wt%.w%. This is because, if the polyimide resin is less than 0.05 wt%, desirable the resistivity cannot be achievedis not maintained, and if the polyimide resin is more than 1.0 wt%, thea density of the electromagnet core 2 cannot bethereof is not easily increased, with the result ~~so~~ that the magnetic flux density and the permeability deteriorate.

———[0026]———

In addition, a flow initiating material 17 described later is mixed into the binder 15.

—[0027]

Now, a method of manufacturing the core 2 is described (see Fig. 3). The molding ~~dieframe~~ 18 includes: a female die 20 in ~~which~~ where a through hole 19 is formed; ~~i~~ an upper punch 21, that is, a male die which is inserted into the through hole 19 in the downward direction thereof; ~~i~~ and a cylindrical core pin 22 and first to third ring-shaped lower punches 23, 24, and 25 which are ~~which~~ inserted into the ~~through~~through hole 19 in the upward direction thereof. The core pin 22 is disposed along an axis z' of the ~~through~~through hole 19, and an upper plane thereof is substantially aligned with an upper plane of the female die 20. The first lower punch 23 is disposed outside the core pin 22 in a concentric manner, and an upper plane 23a thereof constitutes a bottom surface thereof. The second lower punch 24 is disposed outside the first lower punch 23 in a concentric manner, and an upper plane 24a thereof is disposed to be higher than the upper plane 23a in order to form the groove 5 in Fig. 1. The third lower punch 25 is disposed outside the second lower punch 24 in a concentric manner, and an upper plane 25a thereof also constitutes the bottom surface similar to the upper plane 23a. On the other hand, a support hole 26 which the upper plane 22a of the core pin 22 is inserted into is formed ~~through~~on a lower surface of the upper punch 21 along the axis z' . In addition, a heater 27, that is, heating means for maintaining the female die 20 at ~~in~~ a predetermined temperature higher than

a-room temperature, for example, at 120 °C, is provided within to the female die 20.

-----[0028]

In the manufacturing process, the core pin 22 and the first to third lower punches 23, 24, and 25 are inserted into the through hole 19 in advance, and a lubricant layer 29 is formed on a wall surface of the through hole~~through~~ 19 and a wall surface of the a receiving portion ~~2828~~ 29 for receiving a raw material, that is, surfaces of the upper planes 23a, 24a, and 25a and inner and outer surfaces of the lower punch 24. More specifically, an aqueous lubricant solution 29a is sprayed from a spray hole 30 which is disposed above ~~en~~ the upper plane of the female die 20 and in the vicinity of the through hole ~~whole~~ 19 so as to coat the wall surface and surfaces of the receiving portion ~~28. 20.~~ Next, a ~~moisture~~ of the coated lubricant solution 29a is vaporized by using the heat of the female die 20, so that the lubricant layer 29 is formed on the wall surface of the through hole 19, the surfaces of the upper planes 23a, 24a, and 25a, and the inner and outer surfaces of the second lower punch 24. As a lubricant solution, an aqueous solution of 1% sodium benzoate or an aqueous solution of 1% potassium dihydrogen phosphate may be ~~is~~ used. The solution is sprayed and coated on the wall surface which is heated at 120 °C and vaporized, so that the lubricant layer is formed as a deposited

crystallization layer on the wall surface

———[0029]

In the state that the lubricant layer 29 is formed on the wall surface of the receiving portion 28 and the like, a mixture of the soft magnetic powder 14 on which the insulating film 16 is formed, the binder, (for example, 0.2 wt% additive-type polyimide resin region), and the flow initiating material, (for example, 0.01 wt% ethylene bis-stearamide) is dropped and received into the receiving portion 28.

———[0030]

As a flow initiating material, a single bisamide wax ~~single~~ substance such as ethylene bis-stearamide, ethylene bis-laurylamide, or~~and~~ methylene bis-stearamide, or a mixture thereof is preferably used. This is because, the wax just described has a high melting point of 140 °C or more, while the monoamide material thereof has a low melting point, in which case ~~and~~ the flowing property thereof is lowered due to the softening thereof by heat during the ~~at a~~ warm molding process. In addition, as a ~~an~~ flow initiating material, a material formed by adding ~~to~~ 30% or less lithium stearate or 12--hydroxy lithium stearate to the wax mentioned above (including a mixture thereof) is preferably used. This is because, ~~the~~ lithium stearate or 12--hydroxy lithium stearate improves the flowing

property, and its ~~the~~ melting point of 220 °C is high so that ,—
~~and the~~ softening thereof does not occur. The ~~An~~ additive amount
of the flow initiating material to be added is in a range of
from 0.002 wt% to 0.1 wt%, and more preferably, from 0.004 wt%
to 0.05 wt%^o], and a grain size (maximum diameterwidth) of the
flow initiating material is in a range of from 1 μm to 20 μm,
and more preferably, from 1 μm to 10 μm. If the ~~additive amount~~
of the flow initiating material added is less than 0.002 wt%,
sufficient flowing property cannot be obtained, and if the
~~additive amount~~ added is more than 0.1 wt%, sufficient strength
cannot be obtained. If the grain size (maximum diameterwidth) of
the flow initiating material is less than 1 μm, the
manufacturing thereof is difficult, and if the grain size is
more than 20 μm, too much additive amount is needed to obtain
the desired flowing property. In this case, sufficient strength
cannot be obtained.

———[0031]

Next, the upper punch 21 is inserted into the through hole
19 with a predetermined pressure, so that the core 2 is molded.
During the molding, the soft magnetic powder 14 is in contact
with the wall surface of the through hole 19 and also in contact
with the outer surface of the core pin 22, the surfaces of the
upper planes 23a, 24a, and 25a, and the inner and outer surfaces
of the second lower punch 24. In the contacts, since the

lubricant layer 29 is interposed between the soft magnetic powder 14 and the planes of the receiving portion 28, the soft magnetic powder 14 can be pressed, while benefiting from lubrication, ~~in a lubricant state by~~ the female die 20, the upper punch 21, and the first to third lower punches 23, 24, and 25, so that the contact resistance at the planes and surfaces is ~~can be reduced~~ (see Fig. 4). As a result, the press pressure can reach ~~be reached~~ into an inner portion of the molded body, that is, the a pressed body, so that the volume ratio of the soft magnetic powder 14 per unit volume of the molded body can be increased. In addition, since the flow initiating material 17 is interposed between the soft magnetic powder 14 and the receiving portion 28, the press pressure can further reach ~~be reached~~ into the inner portion of the molded body. In addition, the flow initiating material 17 is interposed between the grains of the soft magnetic powder ~~powders~~ 14 and between the soft magnetic powder 14 and the binder 15, so that the press pressure can further reach ~~be reached~~ into the inner portion of the molded body.

———[0032]

When the warm molding process ends, the upper punch 21 is lifted, and the first to third lower punches 23, 24, and 25 are lifted, so that the molded body (core) is extracted from the through hole 19.

———[0033]

Now, a response characteristic (Fig. 6a5a) of the core manufactured according to the present invention and a response characteristic (Fig. 6b5b) of a conventional sintered core are described with reference to Fig. 6. The core according to the present invention has a permeability of $\mu_{\max} = 6 \times 10^{-4}$ H/m, a magnetic flux density of B 10 kA/m: 1.67T, and a resistivity of 500 $\mu\Omega\text{m}$.

On the other hand, the sintered core has a permeability of $\mu_{\max} = 5 \pm 5 \times 10^{-5}$ H/m, a magnetic flux density of B 10 kA/m: 1.57T, and a resistivity of $1 \sim 1.55500$ $\mu\Omega\text{m}$. As a result, the magnetic flux density of the core according to the present invention is close to that of iron, and the resistivity thereof is higher by 2 or 3 orders of magnitude than that of a metal material. As shown by the plunger in flange lift duration data in amount Figs. 6a6a5a and 6b5b, the response characteristics at operation start and end times of the core according to the present invention are superior to those of ~~is better than~~ the sintered core.

———[0034]

According to the aforementioned embodiment, the polyimide resin having a thermally and chemically stabilized molecular structure is used for the binder 15 for the soft magnetic powder 14, so that it is possible to improve the heat resistance and

the chemical resistance in comparison with a conventional core. In addition, the polyimide resin is used for the binder 15, and the ~~volume~~-ratio of the polyimide resin to the soft magnetic powder 14 is in a range of from 0.05 wt% to 1.0 wt%, so that a sufficient resistivity and~~er~~ strength can be obtained. As a result, the molding can be effectively performed. In addition, since the electromagnet 1 provided with the core 2 having an improved heat resistance and~~er~~ chemical resistance is used as a valve control electromagnet of the liquid fuel injector 7 in Fig. 5, the injector attached to an engine can be effectively operated.

~~————[0035]~~

In addition, since the lubricant layer 29 formed on surfaces of the through hole 19 and 28~~or~~ the like of the receiving portion 28 formed in the molding die~~frame~~ 18 improves the a lubricating property between the soft magnetic powder 14 and the surfaces, a friction between the soft magnetic powder 14 and the surfaces of the through hole 19 and 28~~or~~ the like caused by the press pressure during ~~at~~ the molding process can be reduced. As a result, gaps between grains of the soft magnetic powder 14 and between the soft magnetic powder 14 and the binder 15 can be reduced during ~~at~~ the molding process. In addition, the lubricant layer 29 ~~28~~ is formed by vaporizing the moisture of the coated lubricant solution 29a by using the heat

of the receiving portion 28, so that the a thickness of the lubricant layer 29 can be reduced and made uniform. The flow initiating material 17 in addition to the soft magnetic powder 14 and the binder 15 is added, so that the flowing property of the mixture during at the pressing process and ~~or~~ the like can be further improved.

~~———Potential Industrial UsageUsability~~

~~———[0036]~~

An electromagnet core according to the present invention can be used for a measuring valve control electromagnet used for a liquid fuel injector and for other purposes as well~~or others~~.

Brief Description of the Drawings

~~———[0037]~~

Fig. 1 is a perspective disassembled ~~exploded~~ view showing an electromagnet according to an ~~a first~~ embodiment of the present invention.

Fig. 2 is a cross-sectional view showing an internal constitution ~~a main construction~~ of a core according to an ~~the first~~ embodiment of the present invention.

Fig. 3 is a cross-sectional view showing a molding apparatus according to an ~~the first~~ embodiment of the present

invention.

Fig. 4 is a cross-sectional view showing an internal constitution during a main construction of a pressing process according to anthe first embodiment of the present invention.

Fig. 5 is a schematic cross-sectional view showing a partially cut portion of an injector of a liquid fuel injection unit for an engine according to anthe first embodiment of the present invention.

Fig. 6a is a graph showing a response characteristic of a core according to the present invention. The abscissa indicates time., and

_____ Fig. 6b is a graph showing a response characteristic of a conventional sintered core. The abscissa indicates time.

Reference Numerals

———{0038}

2: core

3: coil

7: liquid fuel injector

11: needle-shaped valve

14: magnetic powder

15: binder

17: flowing material

18: molding dieframe

28: receiving portion
29: lubricant layer
29a: lubricant solution